

Work Order ID 108383

October-17-13 9:50:10 AM

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Item ID: DSK078 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: D2893-1 Turning Detail
 Start Date: 10/17/13 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 10/31/13 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 13-10-17 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK078	Rev A								
100		0.00							
100									
Doosan	Memo	0.00	DAS	40	13/11/07	10	Ø		
Doosan Lathe	Turn blank as per Folio FA081 (4TH AXIS PLUG DT8492)		9-89						
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00	DAS	40	13/11/07	10	Ø		
Quality Control			9-89						
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00	DAS	44	13/11/9	10	Ø		
Quality Control			9-89						

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Item ID: DSK078

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: D2893-1 Turning Detail

Start Date: 10/17/13 Start Qty: 10.00 ***10***

Cust Item ID:

Required Date: 10/31/13 Req'd Qty: 10.00 ***10***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						10	0		
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: <u>MAT 60</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

F.K 13/11/09

[Signature] 13-11-11

MF
13-11-11

Picklist Print

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Work Order ID: 108383

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Parent Item: DSK078

DSK078

Parent Item Name: D2893-1 Turning Detail

Start Date: 10/17/13

Required Date: 10/31/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-005		Manufactured	No				Each	8.0000		10			
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D6104-005

**

Round Billet, 17-4

DAS
40 13/11/07
9-89

Location

Loc Qty

Loc Code

MAT043

8

→ 104370

8

→ 108504

8
2

DART AEROSPACE LTD		Work Order: 108383
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.707	2.707	2.708	2.707	2.707
B	4.946	4.966		4.954	4.957	4.956	4.956	4.956
C	3.064	3.084		3.073	3.073	3.074	3.074	3.074
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.934	2.954		2.947	2.946	2.945	2.945	2.945
G	2.166	2.186		2.175	2.175	2.176	2.175	2.176
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.923	.924	.924	.924	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.120	.119	.119	.119	.119
L								
M								
N								
O								
P								

Measured by: ^{DAS} 40	Date: 13/11/07
Audited by: ⁹⁻⁸⁹ 44	Date: 13/11/09
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 108383
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.707	2.708	2.707	2.707	2.707
B	4.946	4.966		4.958	4.957	4.957	4.958	4.956
C	3.064	3.084		3.073	3.074	3.074	3.074	3.074
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.934	2.954		2.944	2.945	2.946	2.945	2.945
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.924	.924	.924	.923	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.119	.119	.120	.119	.119
L								
M								
N								
O								
P								

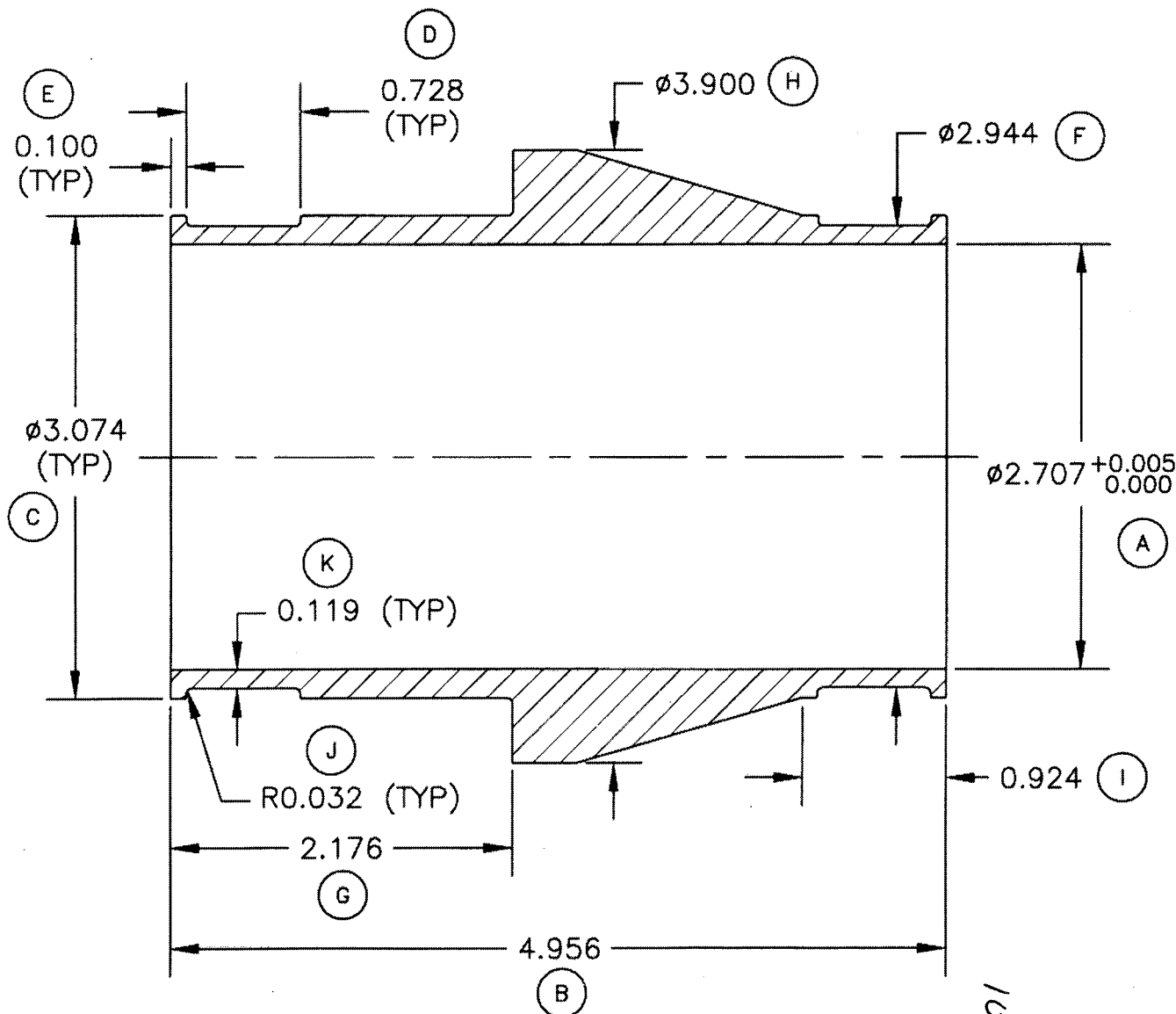
Measured by: DAS 40 9-89	Date: 13/11/07
Audited by: DAS 44 9-89	Date: 13/11/09
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



D2893-1 TURNING DETAIL

108383405
13-10-17

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